

Work Order ID 72043

Monday, July 18, 2011 12:58:17 PM



Page 1

Item ID: D3684-049

Accept



Setup Start



Revision ID:

Stop



Item Name: AFT LEG ASS'Y

Start Date: 7/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 11/07/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3684	Rev D

100	Pick Kit	0.00
-----	----------	------



Packaging	Memo	0.00
-----------	------	------

Packaging

110	Small Fab	0.00
-----	-----------	------



Small Fab	Memo	0.00
-----------	------	------

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

M111791

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

M119508

(2) FF 12-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries






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Revision ID: Stop 
Item Name: AFT LEG ASS'Y
Start Date: 7/18/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/25/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>200</u> Memo	0.00 0.00				<u>12/14</u>	<u>54</u>	<u>20</u>	
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/14/15</u> 

D12-04-5

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, July 18, 2011 12:58:23 PM

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y





Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	40.0000	2	4		② FF 12-04-03	
				<u>Location</u>									
				ST351	120423			40		4			
				117514				4					
				118112				36					
D3688-3  STUD		Manufactured	No			110	Each	3.0000	1	2		② FF 12-04-03	
				<u>Location</u>									
				GA	73459			3		2			
				69625				3					
D3689-1  SLEEVE		Manufactured	No			110	Each	0.0000	1	2		② FF 12-04-03	
					78907					2			
D3691-1  STUD		Manufactured	No			110	Each	14.0000	1	2		② FF 12-04-03	
				<u>Location</u>									
				GA	80363			14		2			
				61370				3					
				62181				11					

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 72043

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

D3692-1 Manufactured No

110 Each

131.0000 4 8



SPACER

Location

Loc Qty

Loc Code

ST075 73232
61 51467

131
131

8

② FF 12-04-03

D3693-1 Manufactured No

110 Each

12.0000 1 2



Rod End Bearing

Location

Loc Qty

Loc Code

GA 00275
50734

12
12

2

② FF 12-04-03

MS21043-3 Purchased No

110 Each

808.0000 2 4



Nut

Location

Loc Qty

Loc Code

FG 118614
103691
ST301 112314
118077

72
72
736
65
671

7

② FF 12-04-03

NAS509-12C Purchased No

110 Each

18.0000 1 2



Nuts

Location

Loc Qty

Loc Code

ST280

18
18

2

② FF 12-04-03

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3684-049



Parent Item Name: AFT LEG ASS'Y

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

NAS509L12C

Purchased

No

110

Each

23.0000

1

2



Nuts

② FF 12-04-03

Location

Loc Qty

Loc Code

ST280

23

112314

13

112828

10

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

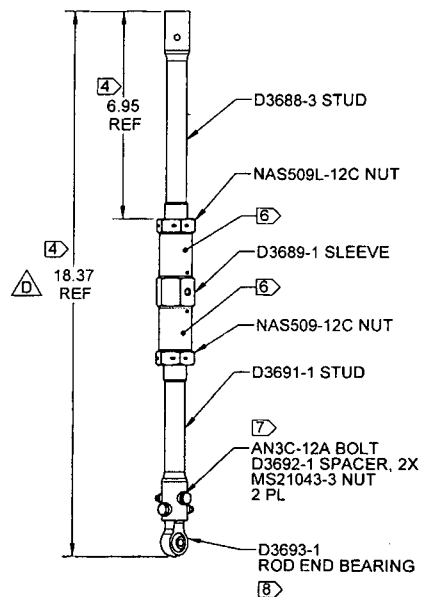
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ITEM	QTY .049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72043
11-07-10







D3684-049 AFT LEG ASSEMBLY



RELEASED
2010-03-15

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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